



DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3288	REV. B SHEET 1 OF 3
DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
7	D2648-3	WEARPAD
9	D2649	CROSS BOLT SPACER
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2656-35	WEARSHOE
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3287-3	WEARSHOE
1	D3289-041	FLOAT WEB
1	D2646	AFT CAP
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3429-1	WEARPAD
64	NAS1330C3KB116	INSERT
66	NAS1515H3L	WASHER
1	NAS1515H4	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
66	MS27039C1-08	SCREW
1	AN4C5A	BOLT

GENERAL NOTES:

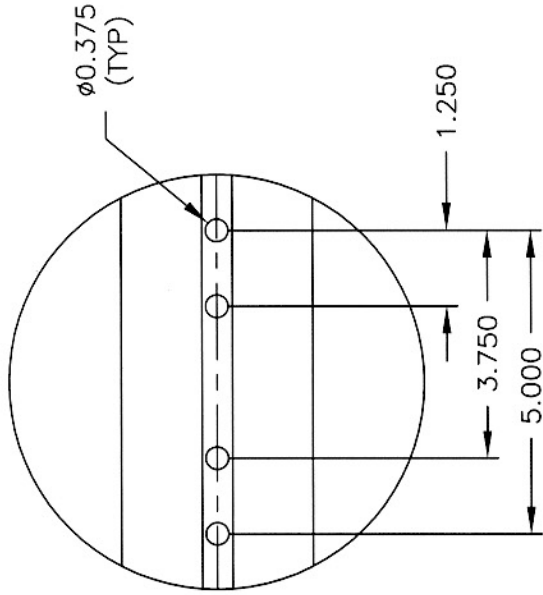
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL 'E' ($\varnothing 0.250$ REF) AND C'SINK $\varnothing 0.391 \times 100^\circ$ FOR NAS1330C3KB116 INSERT USING DT3288-1T2 BEFORE FINISH. INSTALL NAS1330C3KB116 INSERTS AFTER FINISH WITH LPS LABORATORIES "LPS-3".
8. WEARPLATES TO BE INSTALLED WITH A LAYER OF SIKAFLEX-241/-291 ADHESIVE BETWEEN WEARPLATES AND SKIDTUBE.
9. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DESGREASER.

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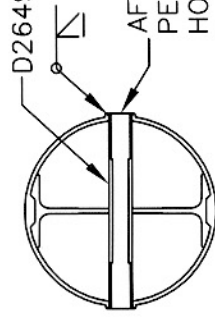
RELEASED
05.08.06

DETAIL A: DRILL DETAIL



DETAIL B

FOR $\phi 0.375$ HOLES ONLY

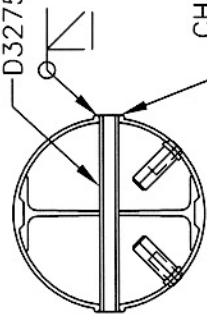


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:

1. CHAMFER HOLE $0.030 \times 45^\circ$
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE TO $\phi 0.313 \times 0.75$ DEEP

DETAIL C

FOR $\phi 0.313$ HOLES ONLY



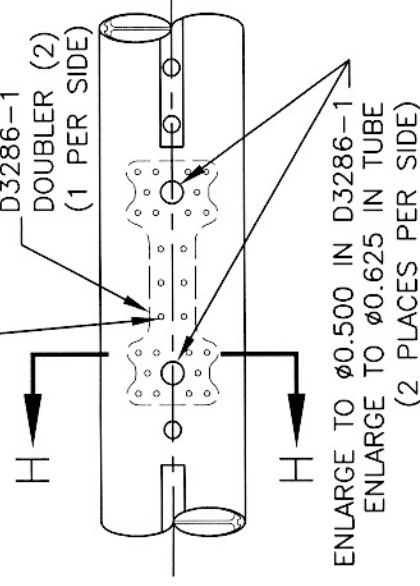
CHAMFER $0.030 \times 45^\circ$ (TYP)

D3275-1 SPACER

DETAIL G

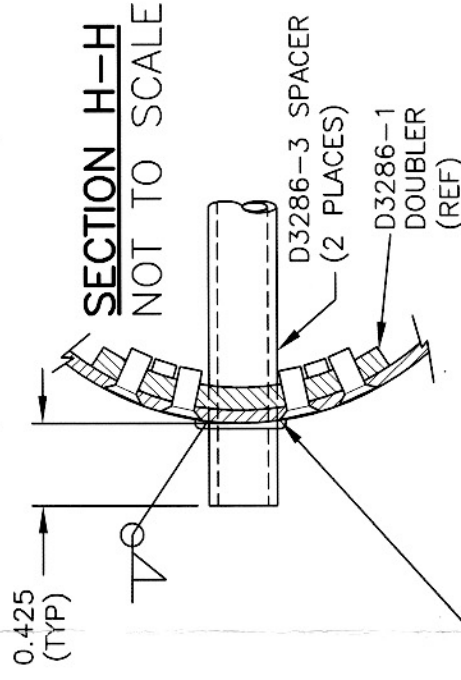
SCALE 1:5

DRILL #30
C'SINK $\phi 0.229 \times 100^\circ$
INSTALL CR3212-4-04
RIVET (26 PER DOUBLER)



ENLARGE TO $\phi 0.500$ IN D3286-1
ENLARGE TO $\phi 0.625$ IN TUBE
(2 PLACES PER SIDE)

SECTION H-H
NOT TO SCALE



TO INSTALL D3286-1/-3:

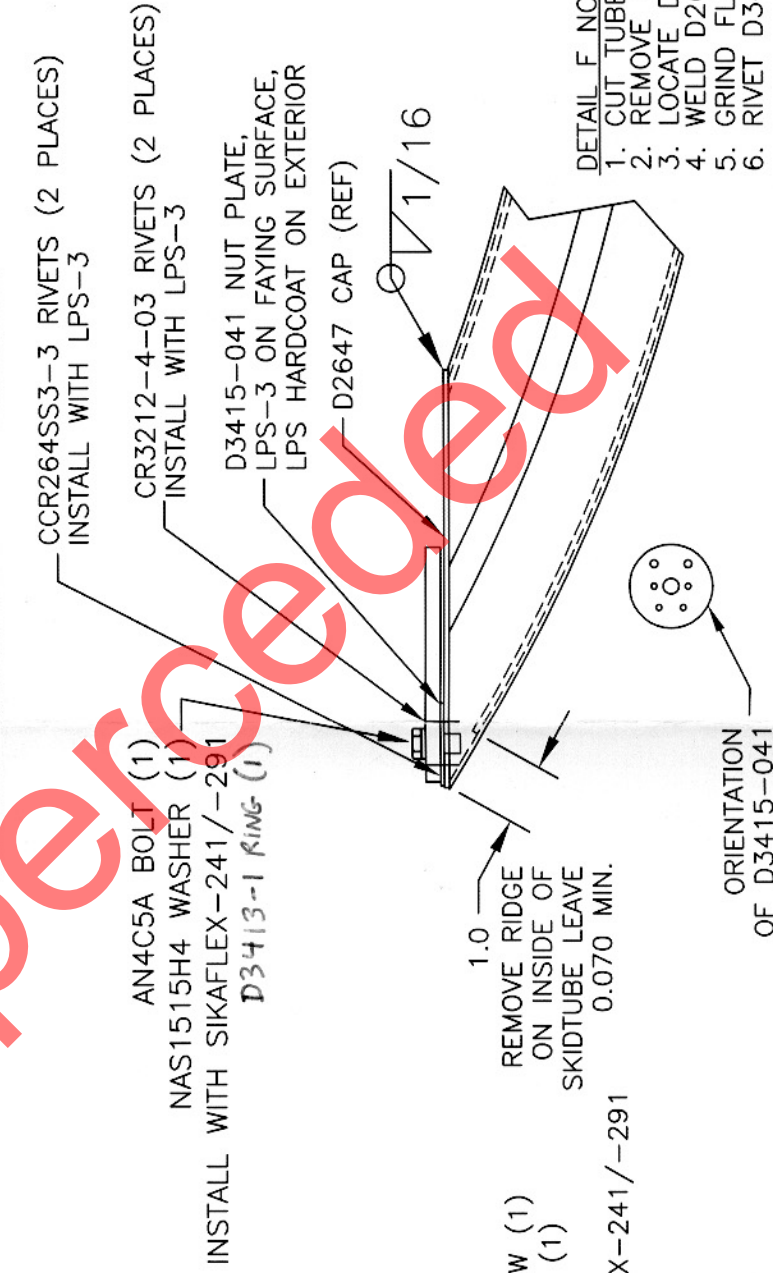
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO $\phi 0.500$
4. ENLARGE HOLES IN TUBE TO $\phi 0.625$
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

DETAIL F NOTES

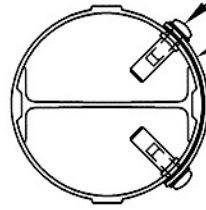
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL



DETAIL D

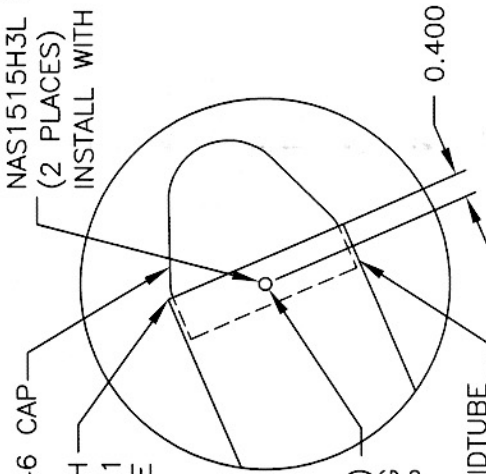


NAS1330C3KB116 INSERT (1)
MS27039C1-08 SCREW (1)
NAS1515H3L WASHER (1)
(64 PLACES)

WEARPAD/WEARSHOE (REF)

DETAIL E

MS27039C1-08 SCREW (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291



D2646 CAP
SEAL WITH SIKAFLEX-241/291 ADHESIVE

$\phi 0.208$ (2 PLACES)
DRILL PRIOR TO INSTALLING D2646 CAP

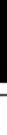


BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL

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CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE	05.03.16	D3288
		TITLE
		SKIDTUBE ASSEMBLY
		SCALE
		1 TO 3

05.09.06 ff



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CHECKED 		APPROVED 		DRAWING NO. D3288		REV. B SHEET 3 OF 3
DATE 05.03.16				TITLE SKIDTUBE ASSEMBLY		SCALE 1:15